

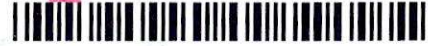


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

D5646-047
Job Sheet 195979



Part No: D5646-047

Job Qty: 1 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Job Created: 6/4/19

Due Date: 6/14/19

Type: Stock

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: URF 19-746 D5646 REV.A IPP REV:A 19.01.15 NEW ISSUE DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE JUN 04 2019 **DATE** 04-06-19

RELEASED **DATE** 19-06-19

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		6/14/19	0.17	0.08	Waterjet - Flow		JRB 6/24/19
110	QC 2	1 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

SCRAP

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120 QC 8	1 pcs	6/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 6/24/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	DAS 40
				QC 8 - 40	JUN 21 2019 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	1 pcs	6/14/19	0.25 0.05	Small Fab - Brake - 1 - B4B	DAS 40 JUN 25 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS 40
				QC 5 - 40	JUN 27 2019 9-89
150 Automated Welding - B4B	1 pcs	6/14/19	0.00 0.08	Automated Welding - 1 - B4B	ML
160 QC 10	1 pcs	6/14/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS 24
				QC 10 - 24	JUL 04 2019
				QC 10 - 43	9-89
				QC 10 - 50	

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170 QC 5	1 pcs	6/14/19	0.00 0.00	QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Handfinish - 4-1-Assembly-B4B	1 pcs	6/14/19	0.00 0.07	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
190 QC 3	1 pcs	6/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
200 Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	1	6/14/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg (D5646-7) Dwg Rev: A Prog Rev: A 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Form as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - ***SEE NOTE 8, FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M38901
 160 - QC10- Inspect visual per QSI004- ground welds
 170 - QC5- Inspect part completeness to step on W/O
 180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 5217452
 190 - QC3- Inspect Part Finish
 200 - Identify as per dwg & Stock LOCATION : FP002
 210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.1330 sf (.133 ea)	100-Waterjet - Flow - 1	<u>5175009</u>

Job Allocations

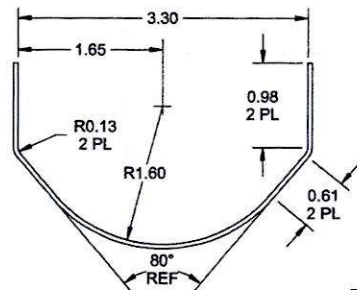
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	0	141	0



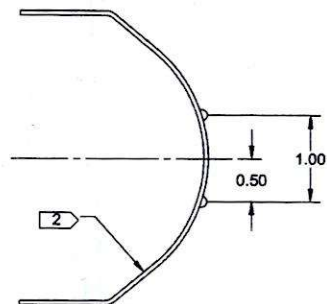
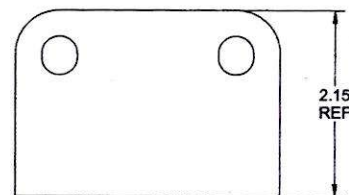
Part Specifications	
Specifications could not be found.	

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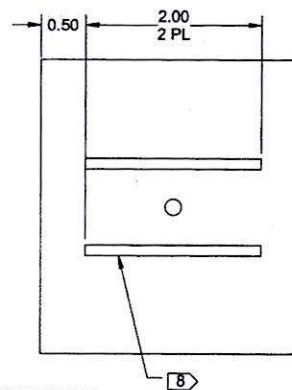
QTY -047	P/N	DESCRIPTION
X	D5646-047	WEARPLATE ASSEMBLY
1	D5646-7	WEARPLATE
A/R	8259	HARDCOAT SURFACING (AUTOMATED WELDING)
A/R	2059B	HARDCOAT SURFACING (MANUAL WELDING)



D5646-7 WEARPLATE
(MAKE FROM D5646-7F)



D5646-047 WEARPLATE ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19577A MJS

19-06-04

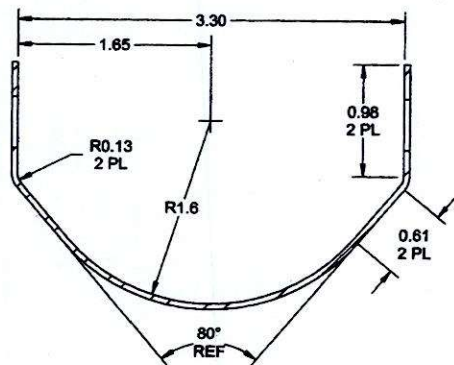
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
- 7) WEIGHT: D5646-047 = 0.3 lbs
- 8) BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER DART QSI 004 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER DART QSI 004 4.1 (MANUAL WELDING)

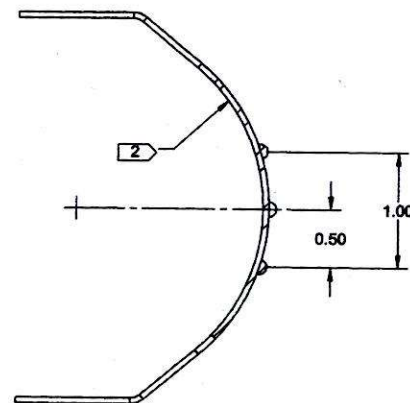
UNDER REVIEW
URF 19-746 19.05.28 (NO)

APPROVED

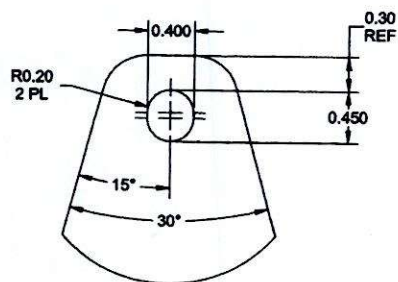
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D5646	REV. A
MFG. APPR.	DD	SHEET 7 OF 9	
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	WEARPLATE ASSEMBLY	NTS
DATE	18.05.25	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A
FORMING DETAIL



SECTION B-B
WELD DETAIL



DETAIL C
LUG DETAIL

UNDER REVIEW
URF 19-746 19.05.28 (NO)

APPROVED	DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5646	SHEET 9 OF 9
	APPROVED	NO	TITLE	SCALE
	DE APPR.	CP	WEARPLATE ASSEMBLY	NTS
DATE		18.05.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>185479</u> Part No. <u>05646-047</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐		
Date : <u>19-11-29</u>	Sequence #: <u>190</u>	QTY Affected : <u>①</u>	MRB (QSI042) DAS 9 9-89 <u>19-11-29</u>	
Description Work Order Deviation		Disposition		Completed By
<u>Part use for trial fit</u>		<u>trial fit was successful</u> <u>scrap destroy wearplate</u> <u>(some damage cause during assembly)</u>		
Lead hand / Supervisor		QC / QA Coordinator DAS 9 9-89 <u>19-11-29</u>		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



Container No: S193262



Part: D5646-047

Job No: 195979

Serial No/Batch: S193262

Revision: A

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Date: 06/24/19